

Date: Wednesday, 03/06/2009 8:49:41 AM  
 User: Melanie Fauteux

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GWT CHAIN PIN
Job Number	: 48344		
Estimate Number	: 13995		
P.O. Number	:	Part Number	: D39549
This Issue	: 03/06/2009 S.O. No. :	Drawing Number	: D3954 REVA
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	:	Material	:
Written By	:	Due Date	: 03/06/2009
Checked & Approved By	: <u>MF 09-06-03</u>	Qty:	<u>2</u> Um: Each
Comment	: Est Rev:A 09-06-02 new issue EC verified by:DD		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	<del>M304R0375</del> <u>M1018-1025</u> 304 ROUND BAR 0.375
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Comment: Qty.: 0.1575 f(s)/Unit Total : 0.1575 f(s)

M1018 ~~304/216 round Bar 0.3750"~~ 1018

Batch: M110860

SA 09/06/03

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: 1-TURN AS PER FOLIO FA & DWG

FOLIO REV: N/A

DWG REV: A

2-DEBURR AS REQUIRED

SA 09/06/03

(2)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 09/06/03

(2)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

MF 09-06-03

(2)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify as per dwg and Stock

Location: \_\_\_\_\_

Dan Stow MF 09-06-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: GWT CHAIN PIN

Job Number: 48344

Part Number: D39549

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/04 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-06-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

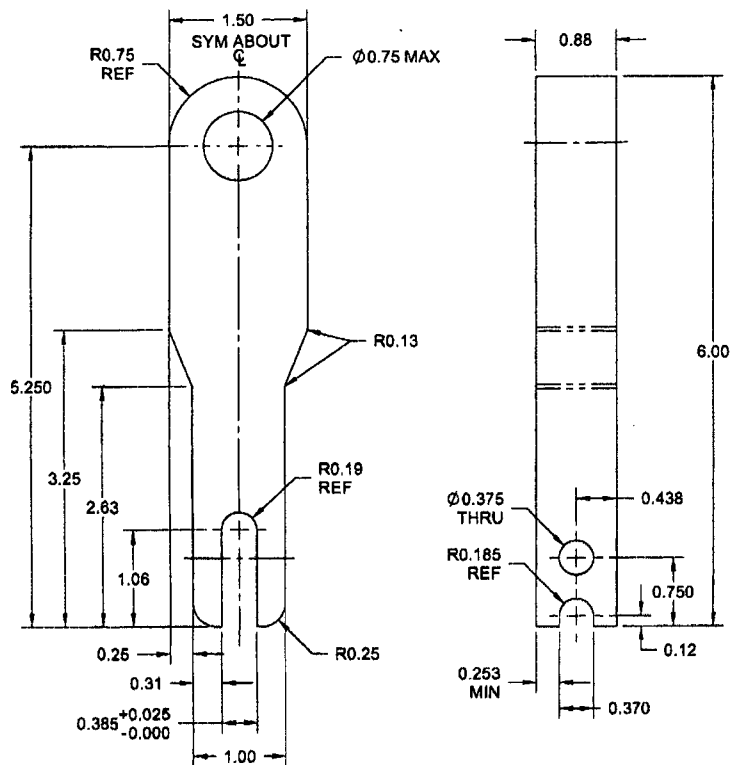
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

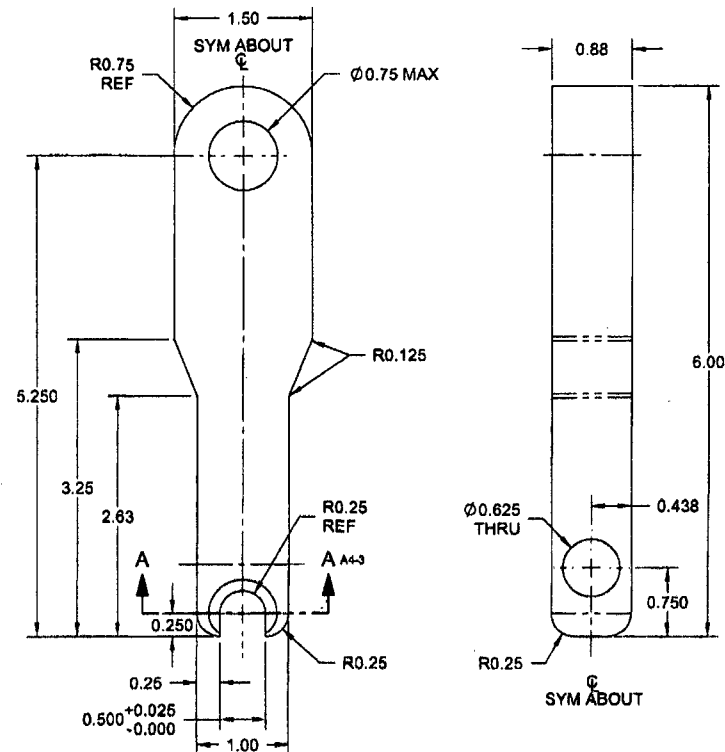
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

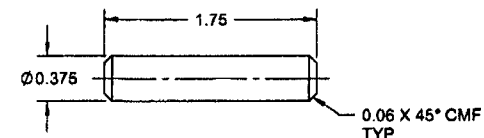




**D3954-5 CHAIN LUG**



**D3954-7 RATCHET LUG**



**D3954-9 GWT CHAIN PIN**

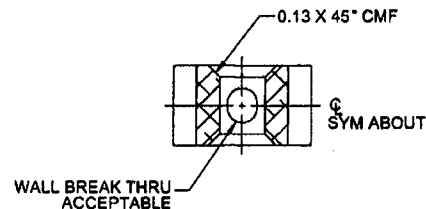
**RELEASED**  
27/05/02

**NOTES:**

1) MATERIAL -5/-7: AISI 303/304 STAINLESS STEEL BAR  
REF DART SPEC M303/304B

-9: AISI 303/304 STAINLESS STEEL ROUND BAR  
REF DART SPEC M303/304R

- 2) FINISH -7 ONLY: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER  
7) WEIGHT -5/-7: 1.56 lbs EACH  
-9: 0.05 lbs



**SECTION A-A C3-3**

DESIGN	AJS/DSTOW	<b>DART AEROSPACE LTD</b>
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. <b>D3954</b>
MFG. APPR.		REV. A
APPROVED		SHEET 3 OF 3
DE APPR.	N/A	TITLE <b>MISC MACHINED PARTS GWT KIT</b>
DATE	09.05.26	SCALE
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